

Date: Friday, 12/12/2008 8:06:32 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT
Job Number	: 44032		
Estimate Number	: 10452		
P.O. Number	:	Part Number	: D32781
This Issue	: 12/12/2008 S.O. No. :	Drawing Number	: D3278 REV. C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 12/12/2008 Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 43418A	Material	:
Written By	: <u>JLM 08.12.12</u>	Due Date	: 19/12/2008 Qty: 40 Um: Each
Checked & Approved By	:		
Comment	: EstA 04.04.19 New issue KJ/JLM est B 07.09.06 rev.c dwg EC verified by: JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X02000	6061-T6 Bar 1.00 x 2.00
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Comment: Qty.: 0.2454 f(s)/Unit Total : 9.8154 f(s)

Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick

(M6061T6B1.000x02.000)

Batch: M110167

J.L 08/12/18

2.0	BAND SAW	BAND SAW
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(40)

Comment: Band Saw

Cut blank: 2.00" x 1.00" x 2.550" long

J.L 08/12/18

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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(40)

Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278

2- Deburr and Tumble

Identify as D3278-1

J.L/DJP 08/12/20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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(40)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L/DJP 08/12/20

5.0	QC8	SECOND CHECK
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(40)

Comment: SECOND CHECK

J.L/DJP 08.12.22

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 44032

Part Number: D32781

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(40)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/12/22

7.0

POWDER COATING

POWDER COATING



M109996



(40X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00
320°F
11:30

M-L 08/12/30

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(40)

Comment: INSPECT POWDER COAT

FL 08/12/30

9.0

PACKAGING 1

PACKAGING RESOURCE #1



90X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

80

8/12/31

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(40)

Comment: FINAL INSPECTION/W/O RELEASE

09/10/105

Job Completion



W 09.01.05

DART AEROSPACE LTD		Work Order: 44032
Description: Support		Part Number: D3278-1
Inspection Dwg: D3278	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

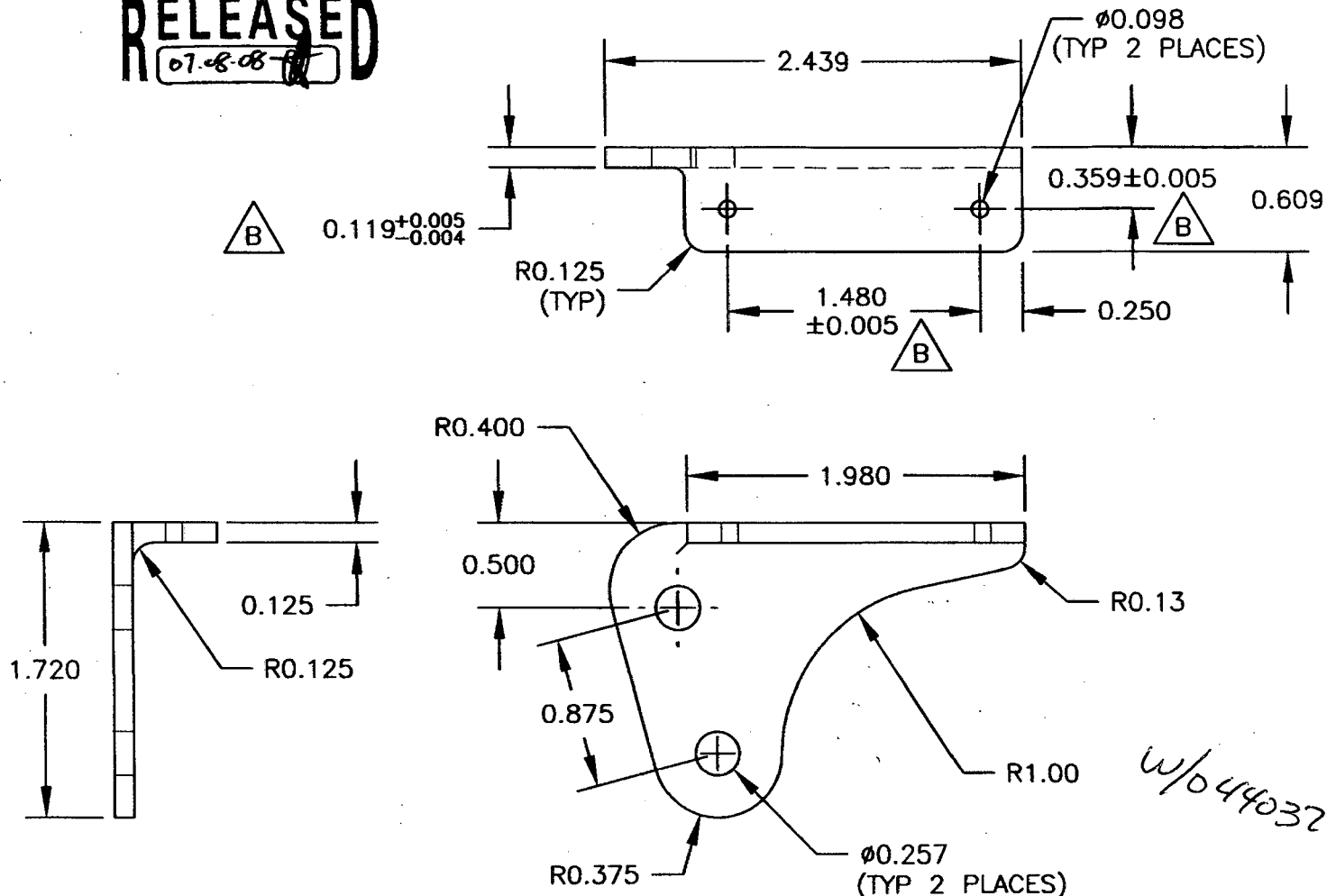
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.098	✓			
0.359	+/-0.005	.359	✓			
0.609	+/-0.010	.614	✓			
0.250	+/-0.010	.251	✓			
1.480	+/-0.005	1.480	✓			
R0.125	+/-0.010	5.125	✓			
0.119	+0.005/-0.004	.122	✓			
2.439	+/-0.010	2.440	✓			
1.980	+/-0.010	1.980	✓			
R0.13	+/-0.030	.130	✓			
Ø0.257	+0.005/-0.000	.260	✓			
R0.375	+/-0.010	.375	✓			
0.875	+/-0.010	.875	✓			
0.500	+/-0.010	.501	✓			
R0.400	+/-0.010	.400	✓			
R1.00	+/-0.030	1.00	✓			
1.720	+/-0.010	1.722	✓			
R0.125	+/-0.010	.125	✓			
0.125	+/-0.010	.127	✓			

Measured by: SL	Audited by:	Prototype Approval:	N/A
Date: 08/12/19	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	

DART

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07-08-08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPR1"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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